

Work Order ID 67908

Monday, April 04, 2011 12:48:07 PM



Page 1

Item ID: D3996-FE-832-EF

Accept



Setup Start



Revision ID:

Stop



Item Name: Self-Clinching Fastener

Start Date: 4/4/2011 Start Qty: 200.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 200.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/04/04 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3996	A								

100

0.00



Purchasing

Memo

0.00

Issue P/O: 13782

Purchase Part Number: FE-832-EF

Supplier: Interfast Inc.

Certificate of conformity is required

CL 11/04/04 200

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

CL 4/4/11 (200)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67908

Monday, April 04, 2011 12:48:07 PM



Page 2

Item ID: D3996-FE-832-EF

Accept



Setup Start



Revision ID:

Stop



Item Name: Self-Clinching Fastener

Start Date: 4/4/2011 Start Qty: 200.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 200.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

J. L. L. 107

Quality Control

1200
x700
04/04/11

130

Identify as per dwg & Stock Location: 103

0.00



Packaging

Memo

0.00

Packaging

10/4/11 200

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/11

MF

11-04-11

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, April 04, 2011 12:48:03 PM

Page 1

Work Order ID: 67908



Parent Item: D3996-FE-832-EF



Parent Item Name: Self-Clinching Fastener


Start Date: 4/4/2011

Required Date: 4/8/2011

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP RevA: new issue 09.11.11 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
FE-832-EF  PEM Insert		Purchased	No			110	Each	0.0000	1	200		4/4/11	(200)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

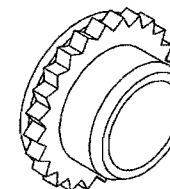
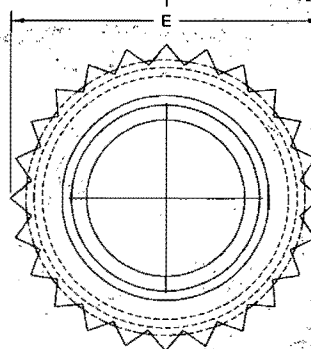
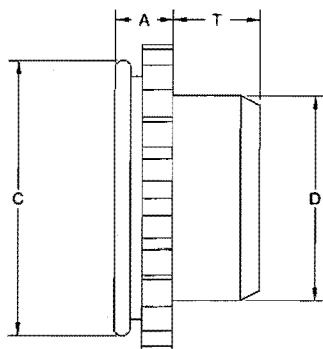
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



CL 11/04/04
W10.67908

D3996-XXX-YYY-ZZZ SELF-CLINCHING FASTENER

THREAD SIZE	THREAD CODE ("YYY")	TYPE ("XXX")	A MAX (SHANK)	SHEET THICKNESS	C +0.000 -0.005	D MAX	E ±0.005	T +0.015 -0.000	HOLE SIZE IN SHEET +0.003/-0.000	MIN DIST. HOLE CL TO EDGE	WEIGHT lb
#4-40 (0.112)	440	FEO	0.040	0.039-0.045	0.171	0.145	0.192	0.065	0.172	0.14	0.00031
		FE	0.060	0.059-0.070							0.00037
#6-32 (0.138)	632	FEO	0.040	0.039-0.045	0.212	0.180	0.244	0.075	0.213	0.17	0.00047
		FE	0.060	0.059-0.070							0.00068
#8-32 (0.164)	832	FEO	0.040	0.039-0.045	0.289	0.215	0.322	0.090	0.290	0.20	0.00098
		FE	0.060	0.059-0.070							0.00124
#10-32 (0.190)	032	FEO	0.040	0.039-0.045	0.289	0.245	0.322	0.110	0.290	0.20	0.00104
		FE	0.060	0.059-0.070							0.00120
1/4-28	0428	FE	0.060	0.059-0.070	0.343	0.318	0.384	0.120	0.344	0.28	0.00158

NOTES

1) SPECIFICATION: PENNENGINEERING (PEM) MINIATURE SELF-CLINCHING FASTENER, SELF-LOCKING
PEM P/N XXX-YYY-ZZZ

WHERE "XXX" = TYPE "FEO" (SHORT SHANK) OR "FE" (LONG SHANK) PER TABLE
"YYY" = THREAD CODE PER TABLE
"ZZZ" = FINISH CODE PER NOTE 2 BELOW

FOR EXAMPLE, #8-32 THREAD, LONG SHANK, ELECTRO-FILM FINISH:
DART P/N = D3996-FE-832-EF
PEM P/N = FE-832-EF

2) FINISH: FINISH CODE ("ZZZ") PER THE FOLLOWING:

"C" = CADMIUM YELLOW CHROMATE PER ASTM B766 CLASS 5 TYPE II
"CI" = CADMIUM CLEAR CHROMATE PER ASTM B766 CLASS 5, TYPE III
"EF" = ELECTRO-FILM PER MIL-PRF-46010
"MD" = MOLYBDENUM DISULFIDE DRY FILM (STD PEM FINISH)

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: N/A

7) WEIGHT: N/A

RELEASED
2009-11-08

A	NEW ISSUE	DESCRIPTION	CP	09.10.01
REV.			BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.10.01			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3996
TITLE SELF-CLINCHING FASTENER
SCALE NTS
REV. A SHEET 1 OF 1

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO13782**

Purchase Order Date 4/4/2011

PO Print Date 4/4/2011

Page Number 1 of 1

Order From :

VC-INT001

INTERFAST INC.
22 WORCESTER ROAD
TORONTO, ON M9W 5X2
CA

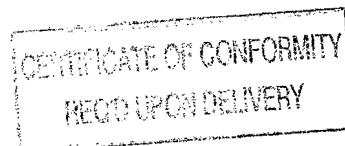
Contact Name		Buyer	Chantal Lavoie
Vendor Phone	416 674 0770	Requisition Nbr	
Vendor Fax	416 674 5804	Tax Resale Nbr	10127-2607
Vendor Account Nbr	110900	Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
Call 11/09/10

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	FE-832-EF	PEM Insert	4/8/2011 Yes	200.00 Each	FedEx PI collect	\$0.2930	\$58.60
			Special Inst: AS PER DWG D3996 REV. A B67908				
2	ALS4-1032-130	Insert	4/8/2011 Yes	2,000.00 Each	FedEx PI collect	\$0.1250	\$250.00
3	ALS7-1032-130	Insert	4/8/2011 Yes	200.00 Each	FedEx PI collect	\$0.1250	\$25.00

PO Total: \$333.60



u CL

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 4/4/2011



22 WORCESTER ROAD, TORONTO, ON, CAN, M9W 5X2
TEL: 1-416-674-0770 FAX: 1-416-674-5804
WEBSITE: www.interfast.ca

Packing Slip



Invoice#:

578954

05-APR-11

SV DART AEROSPACE LIMITED
OE 1270 ABERDEEN ST.
LN HAWKESBURY ON
DD K6A 1K7
U CAN
T
OÀ

SE DART AEROSPACE LIMITED
HX 1270 ABERDEEN ST.
IP HAWKESBURY ON
É CAN K6A 1K7
D
T
I
O
E
R
A

SHIP MODE: Fedex Domestic Within Canada
MODE D'EXPEDITION:

FOB: FOB - Interfast Dock
F.A.B.:

NO. CARTONS: 1

WAYBILL #: 485453229320
FACTURE DE VOIE #:

CUSTOMER PO#
N° DU BON DE COMMANDE:



PO13782

CUSTOMER #:
CLIENT #:

110900

OUR SALE #:
N° DE LA VENTE:

514732

TERMS: Net 30 Days (01)
MODALITES:

QUANTITY ORDERED QUANTITÉ COMMANDÉE	U/M M.N.R.	QUANTITY SHIPPED QUANTITÉ EXPÉDIÉE	BALANCE DUE SOLDE
200.00	EA	200.00	0.00

PART# & DESCRIPTION PARTIE # ET DESCRIPTION	LOT# / Serial#
Cust PO Line#: Cust Part#: FE-832-EF Part#: FE-832-EF Description: NUT ** Packbox#: PACK505488 Lot Line#: 1 Qty: 200 Expire Date Country Of Origin: USA Rev Lvl: Mfg/Cure Date:	D580370001

2000.00	EA	2000.00	0.00
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Cust PO Line#: Cust Part#: ALS4-1032-130 Part#: AELS-1032-130 Description: THIN WALL INSERT Packbox#: PACK505488 Lot Line#: 2 Qty: 1000 Expire Date Country Of Origin: TWN Rev Lvl: Mfg/Cure Date:	00960928R3
Part#: AELS8-1032-130 Description: INSERT Packbox#: PACK505488 Lot Line#: 3 Qty: 1000 Expire Date Country Of Origin: TWN Rev Lvl: Mfg/Cure Date:	00990802R1

